

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004895**Date Inspected:** 25-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay #4

This QA Inspector performed random final visual and magnetic particle (MT) inspections of OBG Edge Plate welds EP077-001-002 and EP077-001-004. The QA Inspector observed the welds appear to comply with project specifications and the Inspector indicated lot number B63 on the green tag document #1956. For additional information on these inspections see the TL6028 Magnetic Particle Test Report.

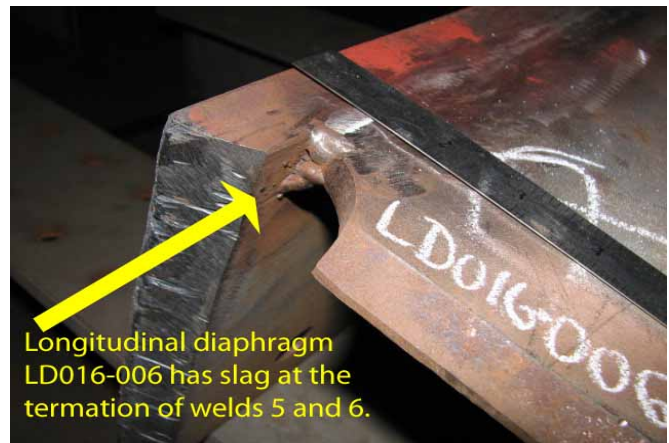
Assembly Bay #2

ZPMC "Notification of Witness Inspection" document # 01487 dated 11-25-2008 lists that OBG longitudinal diaphragm welds LD015-005, LD015-006, LD016-005, LD016-006, LD017-005 LD015-006 in the "Assembly Shop are to be MT inspected and green tagged. The QA Inspector arrived in the assembly bay and asked ABF representative Mr. Li Hanjie where these welds are located and Mr. Li Hanjie informed the QA Inspector that these welds are not in the assembly shop and they are in OBG bay #7. The QA Inspector went to OBG Bay #7 and determined that these welds are not at this location. The QA inspector went to the ABF office where ABF representative Mr. Raymond Mah said he will locate these welds. The QA Inspector and Mr. Mah went to

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assembly bay #2 and Mr. Mah determined these welds are in OBG Bay #8. The QA Inspector accompanied Mr. Mah to OBG bay #8 where it was determined that these welds are not at this location. The QA Inspector asked ZPMC representative Mr. Shen Xue Jun, who had issued this “Notification of Witness Inspection” document to locate these welds and after walking to the back of assembly bay #2 Mr. Shen Xue Jun determined these longitudinal diaphragm assemblies are located inside the OBG near segment 5. The QA Inspector performed random visual inspection of longitudinal diaphragm weld LD016-006-006 and determined the termination of the weld contains slag and does not comply with AWS D1.5 specifications. The QA Inspector showed Mr. Shen Xue Jun the slag and Mr. Jun said this weld will be repaired. The QA Inspector performed random visual inspection of longitudinal diaphragm weld LD018-005-008 and determined the fillet weld does not comply with AWS D1.5 specifications due to insufficient weld size near the end of the weld termination. Mr. Shen Xue Jun said ZPMC will repair these welds. See the photographs below for additional information



Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul
Reviewed By:	Carreon,Albert

Quality Assurance Inspector
QA Reviewer
